

5/25

DART AEROSPACE LTD	Work Order:	23201
Description: 3" Skid extrusion (no outer ridge)	Part Number:	D2600-3-120
Drawing: D2600 Rev. D1	Qty:	120 159

Step	Location	Procedure	By	Date	qty
1	DC	Issue Traveller	RF	05/05/09	120
2	PG	Issue P/O: 7008021 a) Extrude as per Dwg D2600 b) Material: 6061-T6 (QQ-A-200/8) c) Minimum yield tensile strength = 35 ksi d) Minimum ultimate tensile strength = 40 ksi e) Minimum elongation = 8% f) Order at 120" long g) Bon L Canada Inc. tool # 897122 h) To be packed per DSK 066 i) Pull test to ASTM standard B221 required. j) Material certification is required	U	05/05/10	140
3	RG	Inspect for transit damage Ensure certification are attached	CZ	05/09/06	159
4	QC6	Inspect dimensions per Dwg D2600 Check Pull test per Dwg D2600 for compliance page attached. Check hardness with Webster tester	RF	05-12-21	159
5	ST	Identify and Stock	RF	05-12-21	159
6	AC	Cost / part	U	06-09-14	
7	DC	Close W/O Inspect Level 21	LP	06/09/14	159

Rev	Date	Change	Revised By	Approved
A	98.12.02	New Issue	DM	
B	00.01.24	Second Pull test removed	EC	
C	01.03.29	Changed part# to -120	EC	
D	02.09.10	Added DSK 066	KJ RF	

RELEASED
02/09/17 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: DP Date: 26/09/14

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



DESIGN <i>DAK</i>	DRAWN BY <i>DAK</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>AS</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01-04-17	ADD PART NUMBERS + DIE NUMBERS <i>ACP</i>	

RELEASED
98.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
TO ASTM STANDARD B221 BY AN APPROVED TESTING
FACILITY TO ENSURE THAT THE BATCH MEETS THE
ABOVE MINIMUM MECHANICAL PROPERTIES.

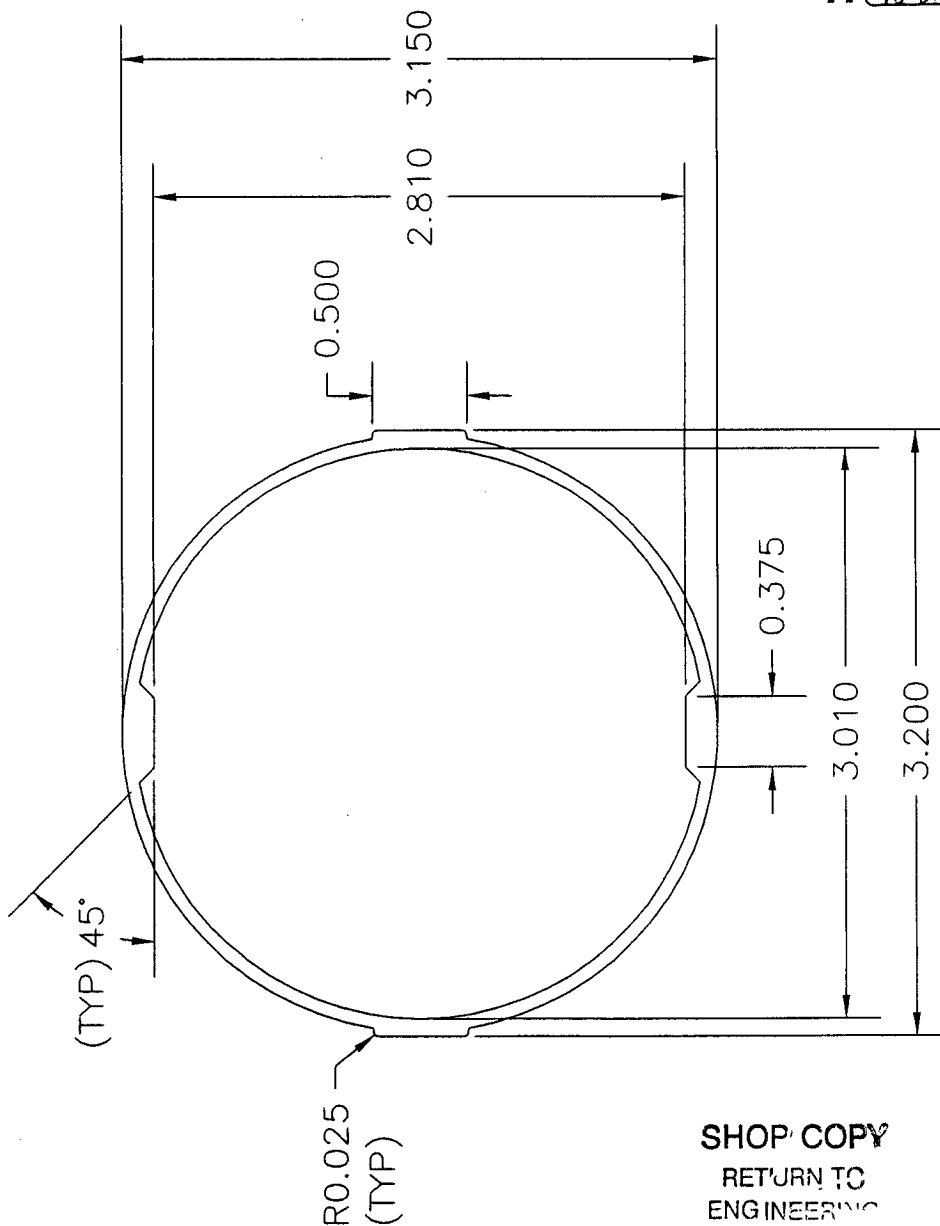
2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

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RETURN TO
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SUBJECT TO / DOCUMENT
WITHOUT NOTICE
WORK ORDER
NO. 23201



DESIGN <i>DA</i>	DRAWN BY <i>DA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>DA</i>	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

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98.8.25 DS



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SUBJECT :
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WORK ORDER
NO. 23201

D2600-1

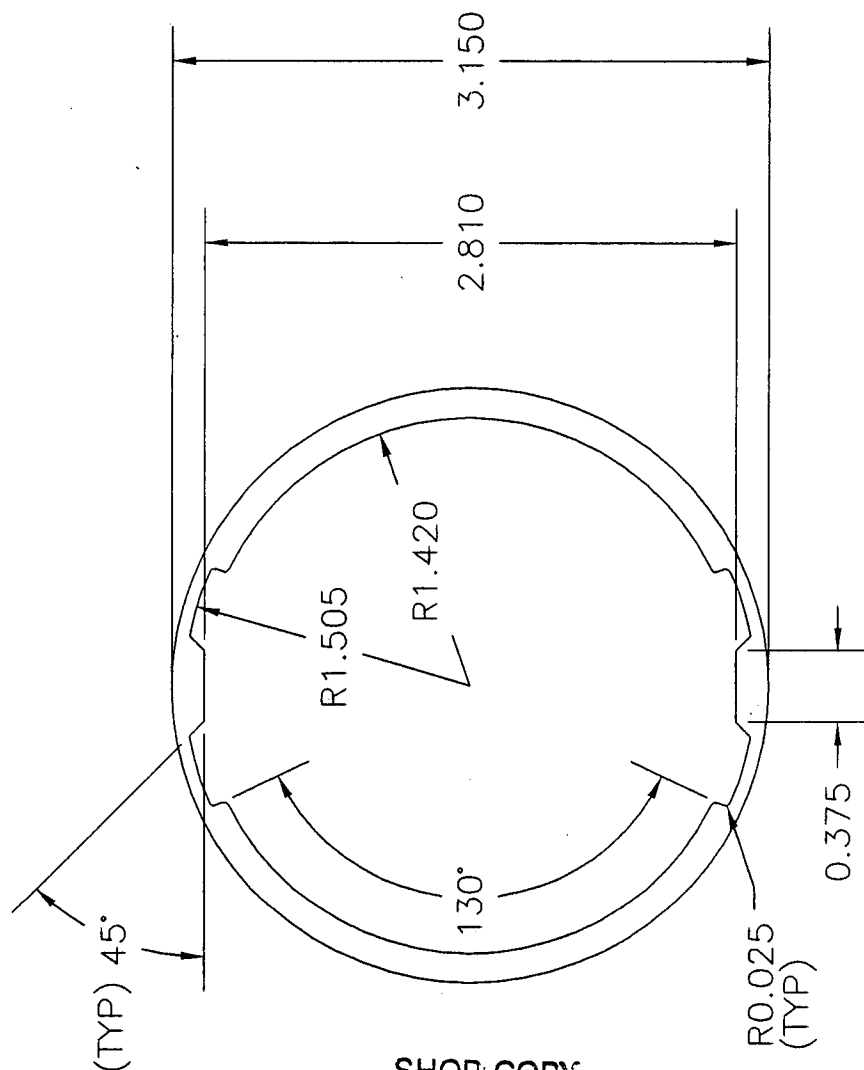
MANUFACTURED WITH CARADON INDALEX DIE # MH-18870
OR BON L DIE # 897121 (PREFERRED CHOICE)
PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)





DESIGN <i>DA</i>	DRAWN BY <i>DA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>CH</i>	DRAWING NO. D2600	REV. D SHEET 3 OF 5
DATE 98.08.20	TITLE EXTRUSION		SCALE 1:1

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WORK ORDER
NO. 23201

D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859

OR BON L DIE # 897122 (PREFERRED CHOICE)

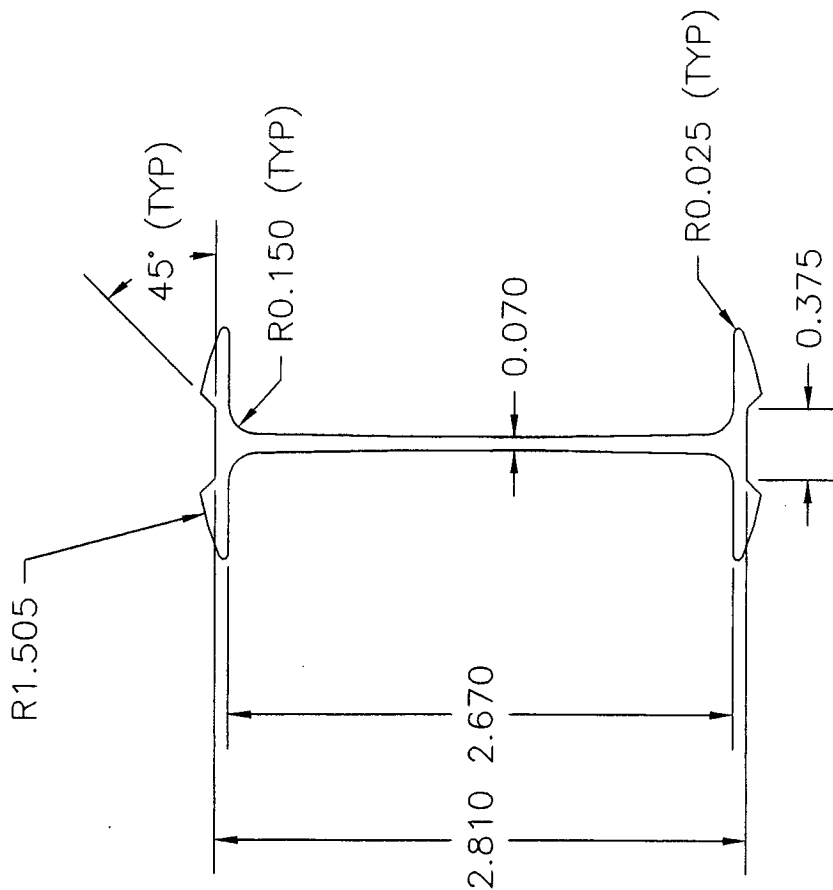
PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)





DESIGN <i>ME</i>	DRAWN BY <i>ME</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2600	REV. D SHEET 4 OF 5
DATE 98.08.20	TITLE EXTRUSION		SCALE 1:1

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98.8.25. DS



D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)



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WORK ORDER
NO. 23201



RELEASED
98.8.25 DS

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 06, 2005
09:55 am

Work Order No : 0023201
Project Name : D2600-3-120
Project For : WK525
Work Order Type : Main
Main WO Number :
House Part Number : D2600-3-120
Description : Extrusion Round 3" 350
Manufactured : Yes
Amount Req'd : 120
Amount Done : 0
Start Date : 05-05-05
Est Finish Date : 06-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

ACCT# 00046024

BON L CANADA INC
1850 CLEMENTS ROAD
PICKERING ON

L1W 3R8

MANIFEST DATE/DATE D'EXPÉDITION

09-04-05

MANIFEST NUMBER/N° D'EXPEDITION

464654

SALES ORDER NUMBER/N° DE COMM.

52195

REFER TO
THESE NUMBERS ON
ALL CORRESPONDENCE.
RÉFÉREZ-VOUS À CES
NUMÉROS POUR TOUTE
CORRESPONDANCE.

CREDIT REP
REP DU CRÉDIT
SMITH, JOANN
770-252-0161

SALES REP
REP. DES VENTES

FIELD SALES REP
REP. REGIONAL DES VENTES
Kutter A
450-435-6551

CUST SERVICE REP
REP SERVICE CLIENTÈLE
burton D
905-427-2227

PHONE 613-632-3336

PHONE 613-632-3336

LOC/USINE

TRAILER NO./N° DE REMORQUE

SALESMAN/VENDEUR

PIC

66141

52305

ISTOMER ID/N° DU CLIENT

ORDER DATE
DATE DE LA COMMANDE

CUST. P.O. NO. N° DE COMM. DU CLIENT

JOB/PROJET	
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BILL OF LADING NUMBER/N° DE CONNAISSEMENT	
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46024

DATE DE LA COMMANDE
05/11/05

2008021

00276456

ITEM NO. ITEM	ORDER QUANTITY QTE COMMANDEE	UNIT UNITE	PREVIOUS SHIPPED QTY QTE DEJA EXPEDIEE	MFG. PART NUMBER N° DE PIECE DU FOURNISSEUR	ALLOY & TEMPER ALLIAGE & TREMP	FINISH DESCRIPTION DESC. DE LA FINITION	THIS SHIPMENT/CETTE EXPEDITION			UNIT UNITE	QUANTITY DUE QUANTITE PREVUE
				CUSTOMER PART NUMBER NUMERO DE PIECE DU CLIENT	LENGTH LONGUEUR	FABRICATION DESCRIPTION TYPE DE FABRICATION	NO. PKGS. N° DE PAQUETS	GROSS WT. POIDS BRUT	NET WT. POIDS NET		
					CUTTING TOLERANCE TOLERANCE DE COUPE	SHIPPING TOLERANCE TOLERANCE D'EXPEDITION					
01	140	KG M PC	0 0 0	DAA-897122-1 D2600-3-120	6061 T6 120" +3/16 " -0 "	MILL CERTIFICATE OF COMP (+010-010,0154-0126)	3	1137	1119	KG M PC	
				DETAIL; LOT/TICKET		52195010 / 144912 52195010 / 144913 52195010 / 144914	1 1 1	379 379 379	373 373 373		53 PC 53 PC 53 PC
							3	1137	1119	KG	
									484	M	
									159	PC	
							TOTALS/TOTAUX				

FORM NO. B1065 REV. C

RETURN MATERIALS WILL BE ACCEPTED FOR CREDIT WITHOUT PERMISSION

REVENIR MATERIEL NE SERA ACCPTE POUR CREDIT SANS AUTORISATION

CUSTOMER
CLIENT

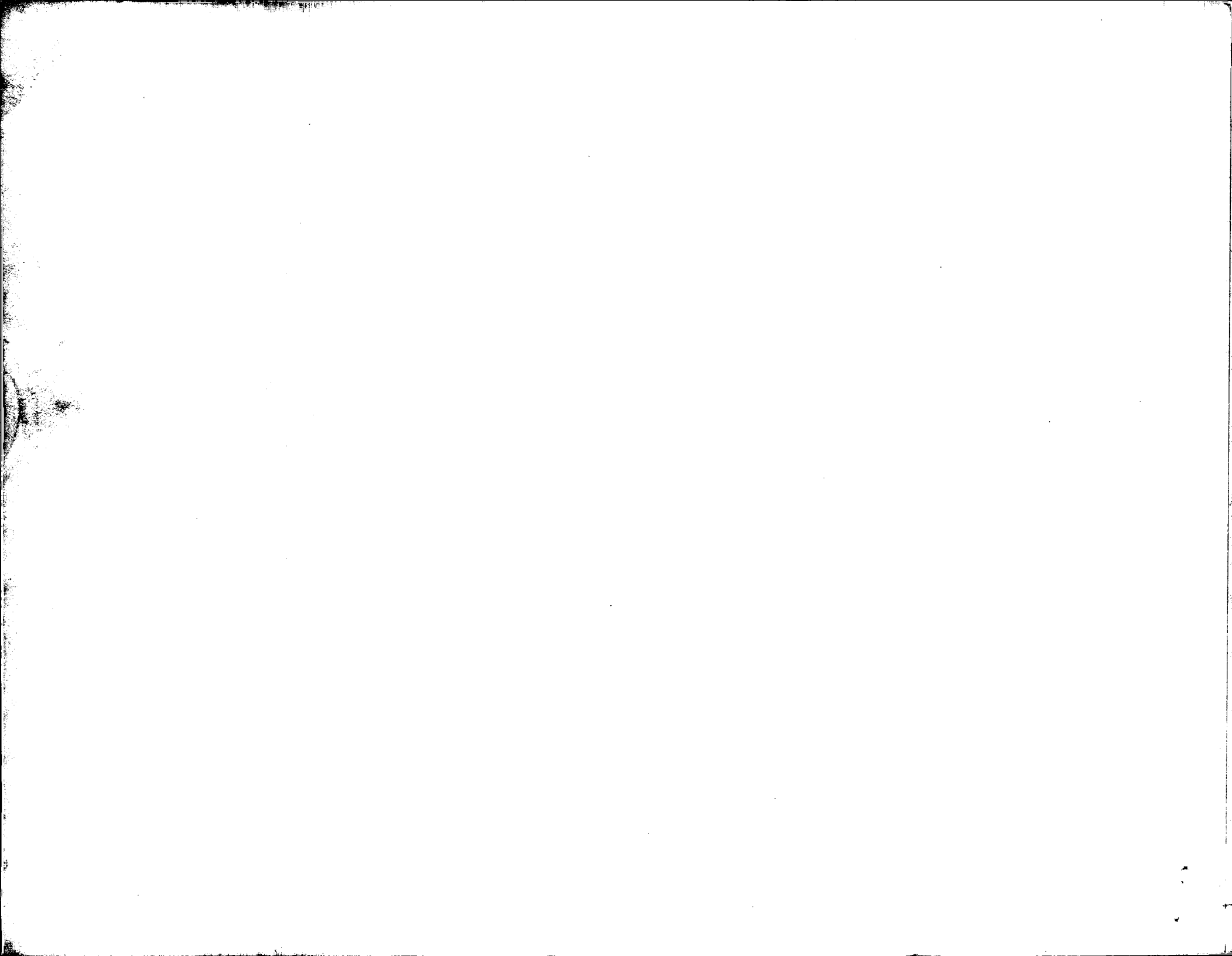
PAGE 1

**CUSTOMER
CLIENT**

PAGE

1

TOTALS/TOTAUX





CERTIFICATE OF COMPLIANCE

BON L CANADA INC

1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8

Cert Date	Cert No	Sales Order	Page
09/04/05	126894	52195	1
Cust PO	B/L No	Lot	Date
2008021	00276456	52195010	9/04/05

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-897122-1	120" Mill 6061 T6	D2600-3-120
Gross Weight	1137 KGS		
Net Qty	1,119 KG	159 PC	485 M 3 PKG

Specification	Die Desc
AMS-QQ-A-200/8 & ASTM B221-00	

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HR-E
1	326.0 / 47.3	304.1 / 44.1	12.5	.0	98
2	332.0 / 48.2	308.0 / 44.7	13.3	.0	98

Chemical Limits:

	SI	FE	CU	MN	MG	CR	ZN	TI	ZR	OTHER
MIN:	.400	.000	.150	.000	.800	.040	.000	.000	.000	EA: .050
MAX:	.800	.700	.400	.150	1.200	.350	.250	.150	.050	TOT: .150

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Conchita Ko, QA Manager Signed for Bon L Canada

Handwritten signature: Conchita Ko

